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NATIONAL AERONAUTICS AND SPACE ADMINISTRATION  
NASA-09675 (September 2004)  
NASA  
Superseding NASA-09675  
(June 2004)  
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SECTION 09675

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**09/04**

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SECTION 09675

HEAVY DUTY EPOXY FLOORING  
09/04

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 NOTE: Delete, revise, or add to the text in this section to cover project requirements. Notes are for designer information and will not appear in the final project specification.

This section covers thin-set, troweled, heavy-duty, epoxy floor toppings.

Thin-set, heavy-duty, troweled floor topping is a mixture of a two-component epoxy-resin binder and a blend of several sizes of pregraded walnut-shell aggregate.

Drawings must show areas of application.

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PART 1 GENERAL

1.1 REFERENCES

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 NOTE: The following references should not be manually edited except to add new references. References not used in the text will automatically be deleted from this section of the project specification.  
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The publications listed below form a part of this section to the extent referenced:

ASTM INTERNATIONAL (ASTM)

- ASTM C 883 (1989) Standard Test Method for Effective Shrinkage of Epoxy-Resin Systems Used with Concrete
- ASTM D 1475 (1998; R 2003) Standard Test Method for Density of Liquid Coatings, Inks, and Related Products
- ASTM D 1544 (1998) Standard Test Method for Color of Transparent Liquids (Gardner Color Scale)
- ASTM D 1652 (1997) Standard Test Method for Epoxy

Content of Epoxy Resins

- ASTM D 2240 (2003) Standard Test Method for Rubber Property - Durometer Hardness
- ASTM D 2471 (1999) Standard Test Method for Gel Time and Peak Exothermic Temperature of Reacting Thermosetting Resins
- ASTM D 2566 (1986) Standard Test Method for Linear Shrinkage of Cured Thermosetting Casting Resins During Cure
- ASTM D 445 (2003) Standard Test Method for Kinematic Viscosity of Transparent and Opaque Liquids (and the Calculation of Dynamic Viscosity)
- ASTM D 523 (1989; R 1999) Standard Test Method for Specular Gloss
- ASTM D 570 (1998) Standard Test Method for Water Absorption of Plastics
- ASTM D 638 (2002a) Standard Test Method for Tensile Properties of Plastics
- ASTM D 638M (1996) Standard Test Method for Tensile Properties of Plastics (Metric)
- ASTM D 696 (2003) Standard Test Method for Coefficient of Linear Thermal Expansion of Plastics Between -30 degrees C and 30 Degrees C
- ASTM D 756 (1993) Standard Practice for Determination of Weight and Shape Changes of Plastics Under Accelerated Service Conditions

THE SOCIETY FOR PROTECTIVE COATINGS (SSPC)

- SSPC SP 6 (2000) Surface Preparation Specification No. 6 - Commercial Blast Cleaning

1.2 SUBMITTALS

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**NOTE: Review submittal description (SD) definitions in Section 01330 SUBMITTAL PROCEDURES and edit the following list to reflect only the submittals required for the project. Submittals should be kept to the minimum required for adequate quality control. Include a columnar list of appropriate products and tests beneath each submittal description.**  
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The following shall be submitted in accordance with Section 01330 SUBMITTAL PROCEDURES in sufficient detail to show full compliance with the

specification:

SD-02 Shop Drawings

Fabrication Drawings shall be submitted in accordance with the paragraph entitled, "Drawings," of this section.

Installation drawings shall be submitted for heavy duty epoxy flooring systems in accordance with the paragraph entitled, "Application of Floor Topping," of this section.

SD-03 Product Data

Manufacturer's catalog data shall be submitted for the following items:

Epoxy-Resin Binder/Matrix  
Cured Epoxy Binder  
Walnut Shell Aggregate  
Surface Sealing Coat

SD-04 Samples

Submit samples on Hardboard in accordance with paragraph entitled, "Sampling," of this section.

SD-05 Design Data

Mix designs (Contractor and job) shall be submitted for the following items including a complete list of ingredients and admixtures. Applicable test reports shall verify that the mix has been successfully tested and meets design requirements.

Epoxy-Resin Binder/Matrix  
Cured Epoxy Binder  
Surface Sealing Coat

SD-06 Test Reports

A copy of the Records of Inspection after completion of the contract in accordance with paragraph entitled, "Quality Assurance," of this section.

SD-07 Certificates

Listing of Product Installations shall be submitted in accordance with paragraph entitled, "Qualifications," of this section.

Certificates shall be submitted for the following showing conformance with the referenced standards contained in this section.

Epoxy-Resin Binder/Matrix  
Cured Epoxy Binder  
Walnut Shell Aggregate  
Surface Sealing Coat

1.3 DELIVERY, HANDLING, AND STORAGE

Materials shall be protected from weather, soil, and damage during delivery, storage, and construction.

Materials shall be delivered in original packages, containers, or bundles bearing brand name and name of material.

Materials used in the installation of floor topping shall be maintained at a temperature between 65 and 85 degrees F 18 and 30 degrees C.

1.4 QUALITY ASSURANCE

A copy of the Records of Inspection, as well as the records of corrective action taken shall be submitted.

1.4.1 Qualifications

A Listing of Product Installations for heavy duty epoxy flooring shall include identification of at least 5 units, similar to those proposed for use, that have been in successful service for a minimum period of 5 years. List shall include purchaser, address of installation, service organization, and date of installation.

Applicators installing the floor topping shall have had experience in the application of troweled walnut-shell aggregate thin-set floor topping.

1.4.2 Sampling

Provide three samples on Hardboard not less than 12 inch 300 millimeter square for each required color.

Panels shall show nominal thickness of finished toppings and color and texture of finished surfaces. Finished floor toppings shall match the approved samples in color and texture.

1.4.3 Drawings

Fabrication Drawings shall be submitted for heavy duty epoxy flooring Systems consisting of fabrication and assembly details to be performed in the factory.

PART 2 PRODUCTS

2.1 MIXES

2.1.1 Epoxy-Resin Binder/Matrix

Epoxy-resin binder shall be a clear two-component compatible system consisting of: (1) a liquid blend of a biphenol-based epoxy resin and an aliphatic polyglyceridyl ether, and (2) a liquid blend of two modified amine curing agents, which will individually cure the epoxy resin at room temperature to a glossy smooth film. Two components and the cured epoxy binder shall have the following physical properties:

<u>PROPERTY</u>	<u>TEST METHOD</u>	<u>REQUIREMENT</u>
COMPONENT A (EPOXY RESIN)		

<u>PROPERTY</u>	<u>TEST METHOD</u>	<u>REQUIREMENT</u>
Viscosity (kinematic), at 77 degrees F, centipoises	ASTM D 445	3000 to 5000
Weight per epoxide, grams	ASTM D 1652	205 to 225
Color (Gardner Color Scale), maximum	ASTM D 1544	5
Weight per gallon, pounds	ASTM D 1475	9.46 - 9.56

COMPONENT B (CURING AGENT)

Viscosity (kinematic), at 77 degrees F, centistokes	ASTM D 445	75 to 125
Weight per gallon, pounds	ASTM D 1475	7.50 to 7.60
Color (Gardner Color Scale), maximum	ASTM D 1544	8

<u>PROPERTY</u>	<u>TEST METHOD</u>	<u>REQUIREMENT</u>
COMPONENT A (EPOXY RESIN)		
Viscosity (kinematic), at 25 degrees C, millipascal-second	ASTM D 445	3000 to 5000
Weight per epoxide, grams	ASTM D 1652	205 to 225
Color (Gardner Color Scale), maximum	ASTM D 1544	5
Weight per milliliter, grams	ASTM D 1475	1.13 - 1.15

COMPONENT B (CURING AGENT)

Viscosity (kinematic), at 25 degrees C, square milliliter per second	ASTM D 445	75 to 125
Weight per milliliter, grams	ASTM D 1475	0.90 to 0.91
Color (Gardner Color Scale), maximum	ASTM D 1544	8

### 2.1.2 Cured-Epoxy Binder

Components A and B shall be combined in the proportions specified by the manufacturer to form a clear compatible system immediately on mixing. Combined components shall cure to a clear film possessing a glossy, nongreasy surface at relative humidities less than 80 percent, and have the following properties after curing 24 hours at 77 degrees F 25 degrees C, followed by 24 hours at 125 degrees F 52 degrees C:

<u>PROPERTY</u>	<u>TEST METHOD</u>	<u>REQUIREMENT</u>
Tensile strength, psi* at test temperature: 77 degrees F	ASTM D 638	4500 to 6500
Tensile elongation, percent* at test temperature: 77 degrees F	ASTM D 638	20 to 40
Weight loss, percent** 24 hours at 300 degrees F	ASTM D 756	6.0
Water absorption, percent 24 hours at 77 degrees F, maximum	ASTM D 570	0.40
Hardness, Shore D	ASTM D 2240	74 to 82
Linear shrinkage, inch/inch maximum	ASTM D 2566	0.006
Shrinkage, glass bow, inch divergence, maximum	ASTM C 883	0.016
Coefficient of linear thermal expansion, inch/inch/degree C, maximum	ASTM D 696 0 degrees C to 40 degrees C	200 X 10 <sup>-6</sup>
Gel time/peak exotherm at 77 degrees F, 100 gm mass in 4-ounce metal container	ASTM D 2471	20 to 40 minutes at 300 degrees F, maximum

\*1/8 inch thick castings

\*\*1/8 by 1 by 3 inch castings, aged in forced draft oven

<u>PROPERTY</u>	<u>TEST METHOD</u>	<u>REQUIREMENT</u>
Tensile strength, kilopascal* at test temperature: 25 degrees C	ASTM D 638M	31000 to 44800
Tensile elongation, percent* at test temperature: 25 degrees C	ASTM D 638M	20 to 40
Weight loss, percent** 24 hours at 150 degrees C	ASTM D 756	6.0
Water absorption, percent 24 hours at 25 degrees C, maximum	ASTM D 570	0.40
Hardness, Shore D	ASTM D 2240	74 to 82
Linear shrinkage, millimeter/millimeter, maximum	ASTM D 2566	0.15

<u>PROPERTY</u>	<u>TEST METHOD</u>	<u>REQUIREMENT</u>
Shrinkage, glass bow, millimeter divergence, maximum	ASTM C 883	0.40
Coefficient of linear thermal expansion, mm/mm/degrees C, maximum	ASTM D 696 0 degrees C to 40 degrees C	200 X 10 <sup>-6</sup>
Gel time/peak exotherm at 25 degrees C, 100 gm mass in 120 millimeter metal container	ASTM D 2471	20 to 40 minutes at 150 degrees C, maximum

\*3 millimeter thick castings

\*\*3 by 25 by 80 millimeter castings, aged in forced draft oven

### 2.1.3 Walnut Shell Aggregate

Walnut shell aggregate shall be delivered to the site in three separate package gradations for blending. Gradations to be furnished shall be:

<u>SIEVE SIZE</u>	<u>PERCENT</u>	
	<u>MAXIMUM</u>	<u>MINIMUM</u>
GRADATION NO. 1		
Retained on No. 6	0.0	-
Passing No. 6, retained on No. 8	5.0	0.0
Passing No. 8, retained on No. 12	100.0	74.0
Passing No. 20	1.0	-
GRADATION NO. 2		
Retained on No. 16	0.0	-
Passing No. 16, retained on No. 18	5.0	0.0
Passing No. 18, retained on No. 40	100.0	85.0
Passing No. 40, retained on No. 60	9.0	0.0
Passing No. 60	1.0	-
GRADATION NO. 3		
Retained on No. 20	0.0	-
Passing No. 20, retained on No. 35	5.0	0.0
Passing No. 35, retained on No. 60	100.0	80.0
Passing No. 60, retained on No. 100	13.0	0.0
Passing No. 100	2.0	-

<u>SIEVE SIZE</u>	PERCENT	
	<u>MAXIMUM</u>	<u>MINIMUM</u>
<u>SIEVE SIZE</u>	PERCENT	
<u>SIEVE SIZE</u>	<u>MAXIMUM</u>	<u>MINIMUM</u>
GRADATION NO. 1		
Retained on 3.35 millimeter	0.0	-
Passing 3.35 millimeter, retained on 2.36 millimeter	5.0	0.0
Passing 2.36 millimeter, retained on 1.7 millimeter	100.0	74.0
Passing 850 micrometer	1.0	-
GRADATION NO. 2		
Retained on 1.18 millimeter	0.0	-
Passing 1.18 millimeter, retained on 1.0 millimeter	5.0	0.0
Passing 1.0 millimeter, retained on 425 micrometer	100.0	85.0
Passing 425 micrometer, retained on 250 micrometer	9.0	0.0
Passing 250 micrometer	1.0	-
GRADATION NO. 3		
Retained on 850 micrometer	0.0	-
Passing 850 micrometer, retained on 500 micrometer	5.0	0.0
Passing 500 micrometer, retained on 250 micrometer	100.0	80.0
Passing 250 micrometer, retained on 150 micrometer	13.0	0.0
Passing 150 micrometer	2.0	-

#### 2.1.1.4 Surface Sealing Coat

Surface sealer shall be nonambering aliphatic or aromatic moisture-curing polyurethane into which has been incorporated a suitable flattening agent. Flattening agent shall be added not more than 24 hours prior to actual application of the coating. Cured coating with flattening agent shall give 60-degree specular gloss of 10 to 20 when tested in accordance with ASTM D 523.

## PART 3 EXECUTION

### 3.1 INSTALLATION

#### 3.1.1 Safety Precautions

Prior to application in confined spaces of toppings and coatings containing flammable or toxic properties, forced ventilation shall be provided to ensure that vapor concentration is kept at acceptable limits recommended by the manufacturer of the product.

"NO SMOKING" signs shall be erected, and smoking or use of spark- or flame-producing devices shall be prohibited within 50 feet 15 meter of any mixing or placing operation involving flammable materials.

Personnel required to handle, mix, or apply toppings containing toxic or flammable properties shall be provided with, and required to wear, such items of personal protective equipment and apparel for eye, skin, and respiratory protection as are recommended by the manufacturer of the product.

Sand blasting shall be accomplished under approved controlled conditions with respect to sand and dust control to prevent damage to personnel and facility.

### 3.2 PREPARATION

#### 3.2.1 Concrete Subfloor

Installation of floor topping shall not commence until concrete has cured a minimum of 28 calendar days. Concrete shall have rough or broom type finish. Prior to applying the prime coat, concrete surface shall be cleaned by an approved method.

#### 3.2.2 Steel Subfloor

Surfaces shall be cleaned of grease, rust, and mill scale by dry sand blasting in accordance with SSPC SP 6 for commercial sand blasting. Contractor shall have the option to use other means of surface preparation, as approved, provided the degree of cleanliness and profile obtained by sand blasting is equaled. Power brushing will not be permitted.

#### 3.2.3 Mixing of Materials

Job mix proportions shall be based on the trial batch proportions used to prepare the floor topping samples submitted and approved. Binder aggregate ratio shall normally range from 1:2 to 1:2.3 (by weight), since mixtures providing satisfactory density, trowelability, and surface texture will be affected by variations in particle shapes, sizes, and size distribution. Three different walnut shell aggregate gradations shall be blended (by weight) as follows: 1 part No. 1; 1.15 parts No. 2; and 1.15 parts No. 3. Minor adjustments of the mix proportions of the approved floor topping samples will be permitted, subject to approval.

Mechanical equipment shall be used for mixing of materials. Rotating replaceable 5- to 16-gallon 20 to 60 liter pail mixers shall be used for blending components A (epoxy resin) and B (curing agent) of epoxy binder.

Rotating paddle-type masonry mortar mixers shall be used for preblending

the three sizes and color pigment, if any, of the walnut shell aggregate and addition of the mixed epoxy resin binder. Mixing times shall be as recommended by the materials supplier(s), provided mixing times result in homogeneous mixtures. In case the equipment used does not provide uniform mixtures in the times recommended, adjustment of the mixing times shall be subject to approval. Quantity of material mixed at one time shall be limited to that which can be applied and finished within the working life of the mixtures. Temperature of materials at the time of mixing shall be between 65 and 85 degrees F 18 and 30 degrees C.

#### 3.2.4 Protection

In addition to the protection of adjacent surfaces during installation, areas used to store and mix materials shall have a protective covering under the materials. After application of the sealer coats, finished flooring shall be protected during the remainder of the construction period. In areas of expected minimum or moderate traffic, floors shall be covered with 70-pound 12300 newton per meter (70 pounds) kraft paper, a 30-30-30 waterproof kraft paper, or an approved substitute, with strips taped together and edges secured to prevent roll-up. Vegetable fiberboard, plywood, or other suitable material that will not mar the flooring shall be placed over the paper to protect areas used as passages by workmen and areas subject to floor damage because of subsequent building operations. Upon completion of construction, the protection shall be removed, flooring cleaned and, where necessary, repaired, resealed, or both, at no additional cost to the Government.

#### 3.3 APPLICATION OF FLOOR TOPPING

Anchor plates set with the top surface at or above the finished epoxy floor level shall not require coverage with this flooring material. Flooring shall extend under equipment, except when the equipment base is indicated to be flush against the structural floor. Surfaces not to receive the epoxy floor topping, such as equipment or cabinets installed prior to surface-preparation efforts and adjacent to the flooring installation, shall be covered, masked, or both.

Prepared subfloor surface shall be dry and at a temperature of not less than 60 degrees F 16 degrees C when application of the floor topping is initiated. Immediately prior to application of the prime/scratch coat on the prepared surface, dust or other loose particles shall be removed by blowing with compressed air or vacuum cleaned. Air compressor used shall be equipped with an efficient oil-water trap to prevent oil contamination or wetting of surface.

A thin roller coat of the epoxy binder specified shall be applied to the prepared subfloor as a prime coat. As an aid to placing, compacting, and finishing the floor topping, the forming of a scratch coat by sprinkling a minimum quantity of the walnut shell aggregate on the prime coat surface immediately following the prime coat application may be employed by the Contractor. Prime coat application rate shall be approximately 150 square feet per gallon 3.7 square meter per liter. Prior to application of the prime/scratch coat, cracks in the concrete shall be filled, and provisions shall be made to keep control or expansion joints open.

Placement of the floor topping shall be made prior to final gelling of the prime/scratch coat. Immediately after the materials are mixed as specified, the mixture shall be dumped in the placement area and spread to prolong troweling life. Placed materials shall be screeded or rough

troweled to the specified thickness and then compacted by the use of a smooth roller prior to finish troweling to a nominal thickness of 3/16 inch plus or minus 1/16 inch 4.7 millimeter plus or minus 1.58 millimeter. Finished surface shall be free of ridges, hollows (bird-baths), and trowel marks, and smoothness shall vary not more than 1/8 inch 3 millimeter when tested with an 8-foot 2500 millimeter straightedge. Provisions shall be made to maintain the work areas in a relatively dust-free environment during curing of the topping.

After the floor topping has set firmly (approximately 6 to 16 hours depending on subfloor temperature) in a relatively dust-free environment, two thin coats of the sealer coat, shall be applied by means of brush, roller, squeegee, or notched trowel to provide a pore-free, easy-to-clean surface. At the time of sealer application, the surface shall be dust-free. Depending on relative humidity, the applied sealer shall cure to a tack-free condition in 2 to 4 hours. Second coat shall not be applied until after the initial coat has cured to a tack-free, hard film. Topping areas shall be maintained in a relatively dust-free environment during curing of the sealer coats.

### 3.4 FIELD QUALITY CONTROL

#### 3.4.1 Repairing

Damaged and unacceptable portions of completed work shall be removed and replaced with new work to match adjacent surfaces at no additional cost to the Government.

### 3.5 CLEANING

Surfaces of the new work, and adjacent surfaces soiled as a result of the work, shall be cleaned. Equipment, surplus materials, and rubbish from the work shall be removed from the site.

-- End of Section --